

Work Order ID 56346

Thursday, February 18, 2010 12:07:39 PM

Page 1

Item ID: D3265-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Basket Base Assembly

Start Date: 2/19/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 2/25/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *10-2-18*

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3265

Rev C

100

Weld per dwg A/R S.S. rod Batch: *11109213* 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Drill hole in D3265-3 as per Dwg D3265
2-Remove all markings from material
3-Weld as per Dwg D3265 using DT9444 Deburr as required
4-cut mesh

10.02.25

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

10.02.25

120

QC6- Inspect dimensions to drawing 0.00



QC

Memo

0.00

Quality Control

8 10/12/25

Q

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Powdercoat

Powder Coating

Operation
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Pressure Wash
M113170

Set Up/
Run Hours

0.00

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

⇒ M

10/03/02

(X1)

Ø

Memo

1ST COAT:

START TIME:

10:15am

OVEN TEMPERATURE:

400°C

FINISH TIME:

10:45am

****if necessary****

2ND COAT:

START TIME:

11:00am

OVEN TEMPERATURE:

400°C

FINISH TIME:

11:30am

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

9/10/03/03 0

Dart Aerospace Ltd

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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Small Fab

Small Fab

Small Fab

Memo

Seal support gusset seam with White Sikaflex-291

Batch: 1112345

Expiry date: 10/08

0.00

0.00

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: C-A

Memo

0.00

0.00

Cust Item ID:

Customer:

950/03/03 @

SB 10/03/03 @

950/03/03 @

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/03/05
MF
10-3-4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Thursday, February 18, 2010 12:07:39 PM

Page 1
4

Work Order ID: 56346



Parent Item: D3265-041

Parent Item Name: Basket Base Assembly

Start Date: 2/19/2010

Required Date: 2/25/2010

Comments: IPP Rev:C Re-Format 05-11-03 JLM
IPP Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verified by:EC IPP
RevE: as per DEO DD 10.09.12 verified by:EC IPP RevF: revise seq
110 DD 10.01.28 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D2232-3 Manufactured No 100 Each 19.0000 2.0000



Basket Hinge



SAD 10-02-22

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	19
50024	2
54863	17

D2235-1 Manufactured No 100 Each 16.0000 1.0000



Basket Rib



SAD 10-02-22

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA	16
50565	3
55719	3
55979	10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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RevE: as per DEO DD 10.09.12 verified by:EC IPP RevF: revise seq
110 DD 10.01.28 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D2327-3

Manufactured No

100

Each

51.0000

2.0000



Spacer Bushing



SAD 10-02-22

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

44274

4

44365

9

Main Warehouse

WA

38

55167

18

55917

20

2

D2581

Manufactured No

100

Each

15.0000

2.0000



Mounting Bracket



SAD 10-02-22

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

12

46086

2

48428

1

51120

2

54862

7

2

Main Warehouse

WA

3

50872

1

51745

2

Thursday, February 18, 2010 12:07:39 PM

Shop Packet Print

Page 2

Dart Aerospace Ltd

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 110 DD 10.01.28 verified by:EC

Start Date: 2/19/2010

Required Date: 2/25/2010

Start Qty: 1.00

Required Qty: 1.00

D3442-5 Manufactured No 100 Each 60.0000 4.0000



Shim



SAD 10-02-22

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

60

33282

60

D326-041

Manufactured No

100

Each

6.0000

2.0000



Rib / Gusset Assembly



4

SAD 10-02-22

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

6

55841

6

D3833-1

Manufactured No

100

Each

11.0000

2.0000



Mesh (Base End Face)



2

SAD 10-02-22

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

11

50025

2

55843

9

2

Thursday, February 18, 2010 12:07:39 PM

Shop Packet Print

Page 3

Dart Aerospace Ltd

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 RevE: as per DEO DD 10.09.12 verified by:EC IPP RevF: revise seq
 110 DD 10.01.28 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

1,072.652 27.3684



SAD 10-02-22

Expanded Metal Flat SS

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

1072.652006

111956

0.000017

112147

9.4736E-06

112949

32.58138

113205

0.0093

113497

0.1449

113555

773.4991

113904

266.4173

M304TS0.750W.065

Purchased

No

100

f

448.7902 19.2632



SAD 10-02-22

304 SQ Tube .75x.75x.065W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

448.7901712

113082

0.00419

113245

0.00038421

113683

16.30855

113836

52.477047

113956

380

Main Warehouse

WA

0.0000047

112398

0.0000047

19.2632

Thursday, February 18, 2010 12:07:39 PM

Shop Packet Print

Page 4

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QTY -041	PART NUMBER	DESCRIPTION
X	D3265-041	BASKET ASSEMBLY
2	D2232-3	HINGE PLATE
4	D2235-1	RIB
4	D2325	SUPPORT GUSSET
2	D2327-3	BUSHING
2	D2581	MOUNTING BRACKET
2	D3265-1	RIB
2	D3265-3	RIB
2	D3265-5	RIB
2	D3442-5	SHIM

#56346

DEO ATTACHED

RELEASED



NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

C	DRAWING UPDATED TO CURRENT STANDARDS. SHT 4 ADDED. RIB MATERIAL WAS 0.060 THICK. SHT 2 ZONE D5 25.63 DIMENSION WAS 27.63.	AJS	08.08.14
B	INCORPORATED A1. ADD SHIM UNDER HINGES. ADD HOLES FOR SPLIT LID BASKETS.	PH	05.06.08
A	NEW ISSUE	CP	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3265	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.08.14	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

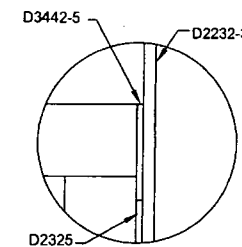
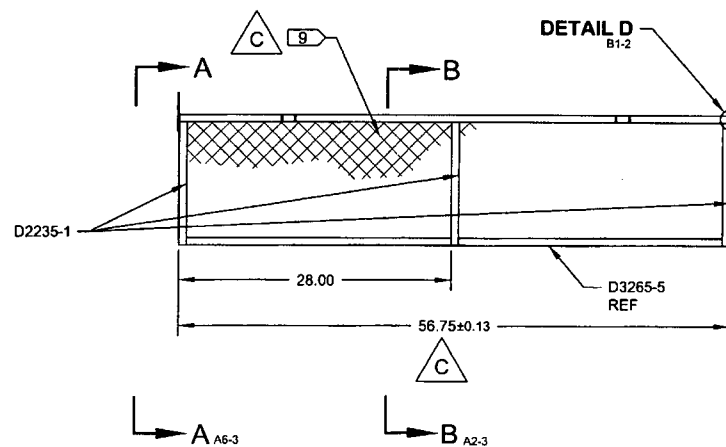
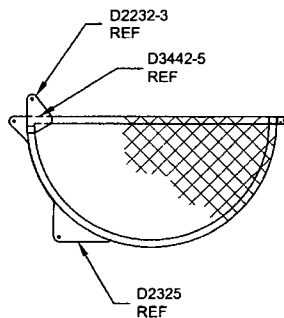
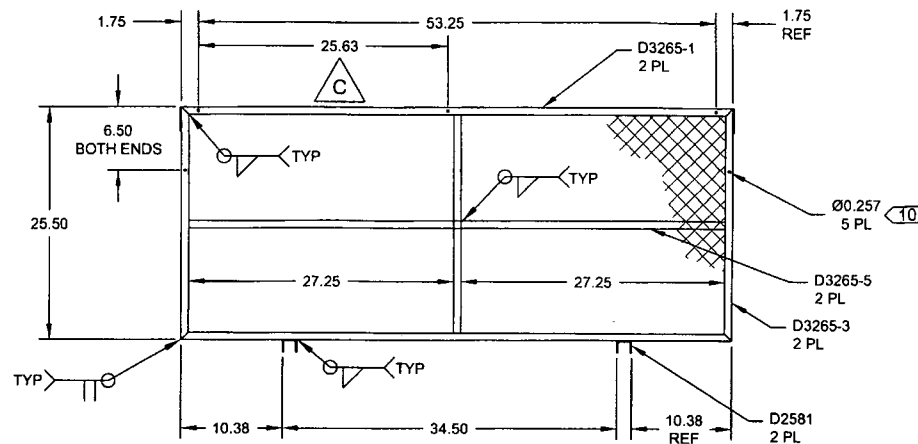
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NOTE: Date & initial all entries



DETAIL D C4-2
(BOTH ENDS)
SCALE 10X



BASE ASSEMBLY NOTES:

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) SKIN INSIDE SURFACE OF BASKET WITH EXPANDED STEEL MESH.
TACK WELD EACH END OF STRAND TO FRAME.
- 10) DRILL WHEN ASSEMBLING WITH D3267-041/-043 LID ONLY.

D3265-041 BASKET BASE ASSEMBLY

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3265	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.08.14	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

DEO ATTACHED
RELEASED
[Signature]

56346

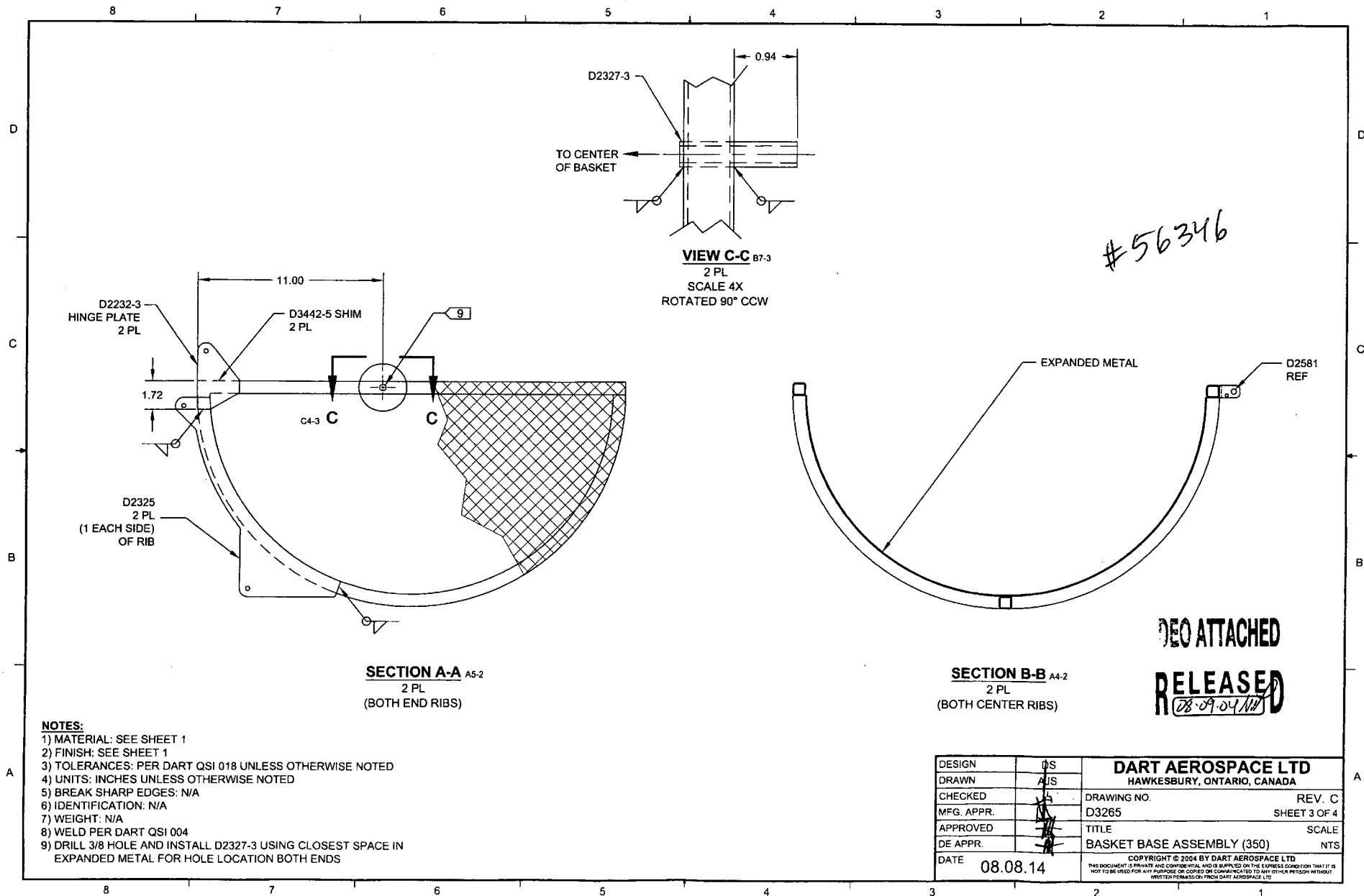
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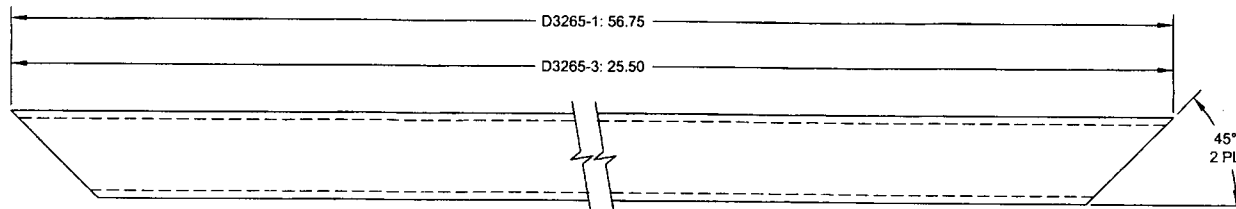
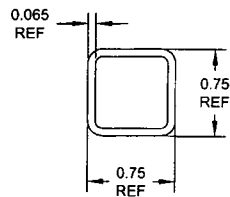
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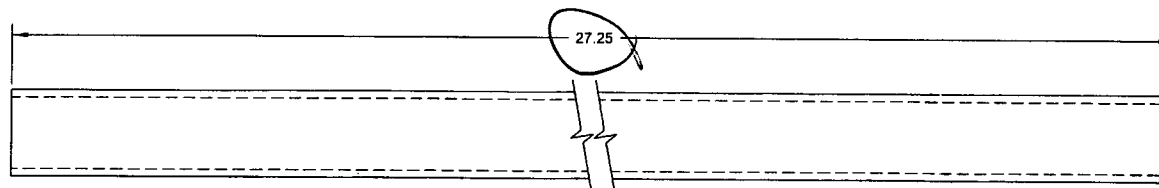
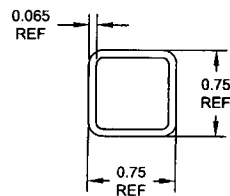
NOTE: Date & initial all entries



D3265-1 RIB

D3265-3 RIB

#56346



D3265-5 RIB

DEO ATTACHED
RELEASED
08.08.14

NOTES:

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3265	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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DRAWING NO. D3265	TITLE BASKET BASE ASSEMBLY (350)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3265-C-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN <i>[Signature]</i>	CHECKED <i>PH</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 09.04.16	DATE 09.04.16	DATE 09.04.16	DATE 09.04.16		DATE 09.04.16		

SHEET 1, MODIFY PARTS LIST AS FOLLOWS:

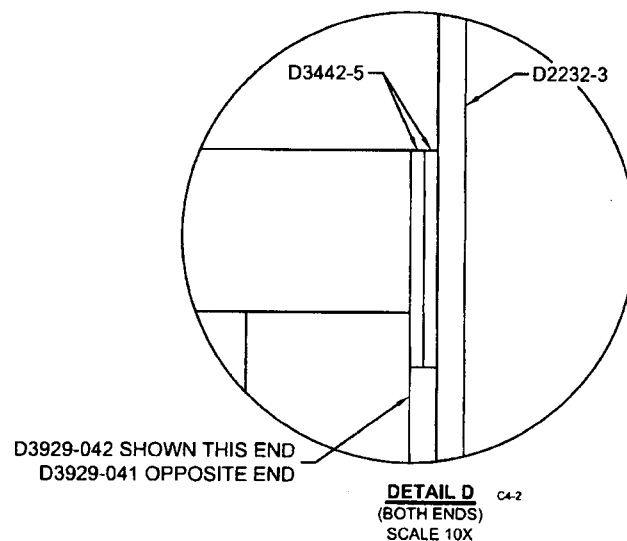
IS:

QTY -041	PART NUMBER	DESCRIPTION
X	D3265-041	BASKET ASSEMBLY
3	D2235-1	RIB
2	D3929-041	GUSSET ASSEMBLY
2	D3929-042	GUSSET ASSEMBLY
4	D3442-5	SHIM

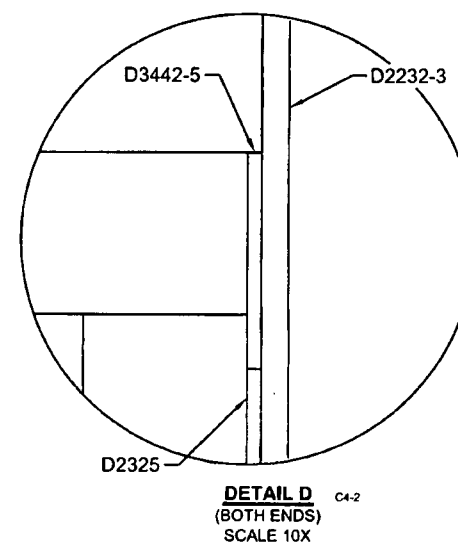
WAS:

QTY -041	PART NUMBER	DESCRIPTION
X	D3265-041	BASKET ASSEMBLY
4	D2235-1	RIB
4	D2325	SUPPORT GUSSET
2	D3442-5	SHIM

SHEET 2, MODIFY DETAIL D AS SHOWN:



RELEASED
01/04/22



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

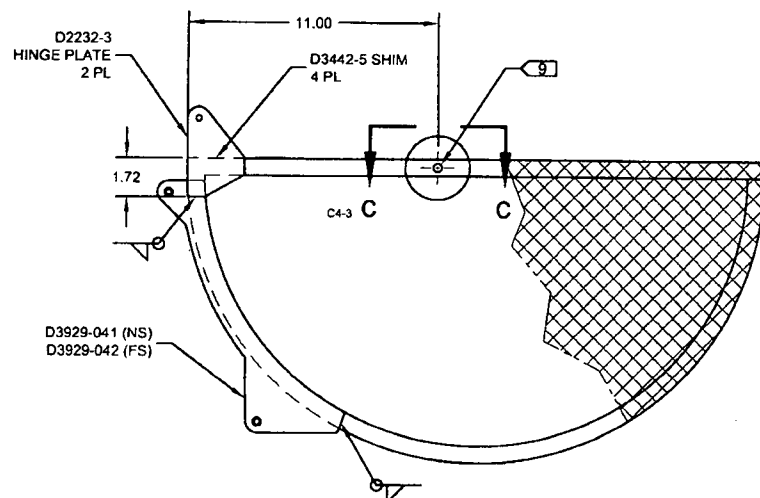
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3265	TITLE BASKET BASE ASSEMBLY (350)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3265-C-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN <i>B</i>	CHECKED <i>PH</i>	MFG. APPR. <i>AS</i>	APPROVED <i>PH</i>	DE APPR. <i>PH</i>		
DATE 09.04.16	DATE 09.04.16	DATE 09/04/17	DATE 09.04.17	DATE 09.04.17		

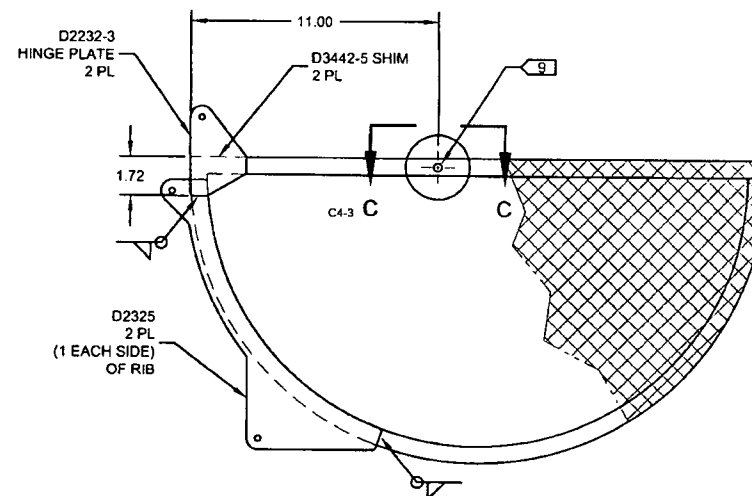
SHEET 3, MODIFY SECTION A-A AS SHOWN:

IS:



SECTION A-A AS-2
2 PL
(BOTH END RIBS)

WAS:



SECTION A-A AS-2
2 PL
(BOTH END RIBS)

56346

RELEASED
09/04/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries